

Date: Wednesday, 5/23/2007 3:24:43 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
 Job Number : 32474  
 Estimate Number : 12108  
 P.O. Number : *N/A* Part Number : D32013  
 This Issue : 5/23/2007 S.O. No. : *N/A* Drawing Number : D3201 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : SMALL / MED FAB Drawing Revision : B  
 Previous Run : 30828 Material : *N/A*  
 Due Date : 6/6/2007 Qty: 20 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: A Removed from 9 Digit 06-01-25 JLM  
 Est Rev: B Now on Waterjet 06-08-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.0473 sf(s)/Unit Total : 0.9450 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
 (M2024T3S.050)  
 Batch: *M103321*

*SAD 07/06/05*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3201  
 Dwg Rev: *B*  
 Prog Rev: *B*

*SAD 07/06/05*

*(20)*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/06/05*

*20*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*SAD 07.06.05*

*20*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr Stack

*SAD 07/06/05*

*20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ED Date: 07/06/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32474

Part Number: D32013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3201

SB 07/06/14 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Counters  
L 15 07/06/20 X 20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 07/06/25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/06/20 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STS

07/06/20 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/20 (20)

Job Completion



07/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32474
Description: Doubler		Part Number:	D3201-3/-4
Inspection Dwg: D3201      Rev: B			Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

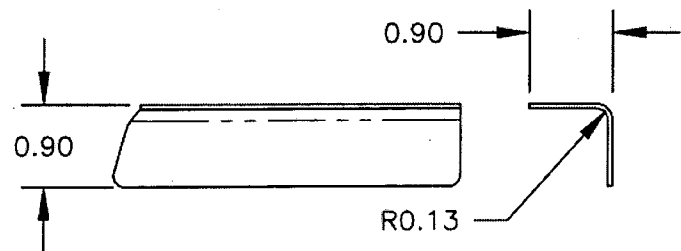
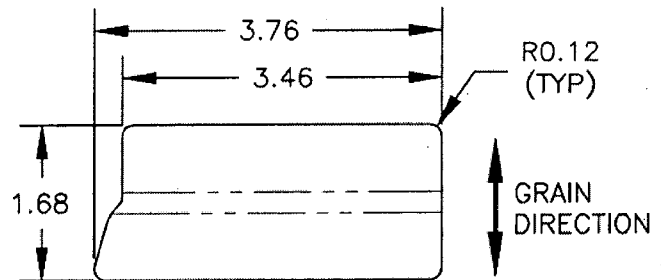
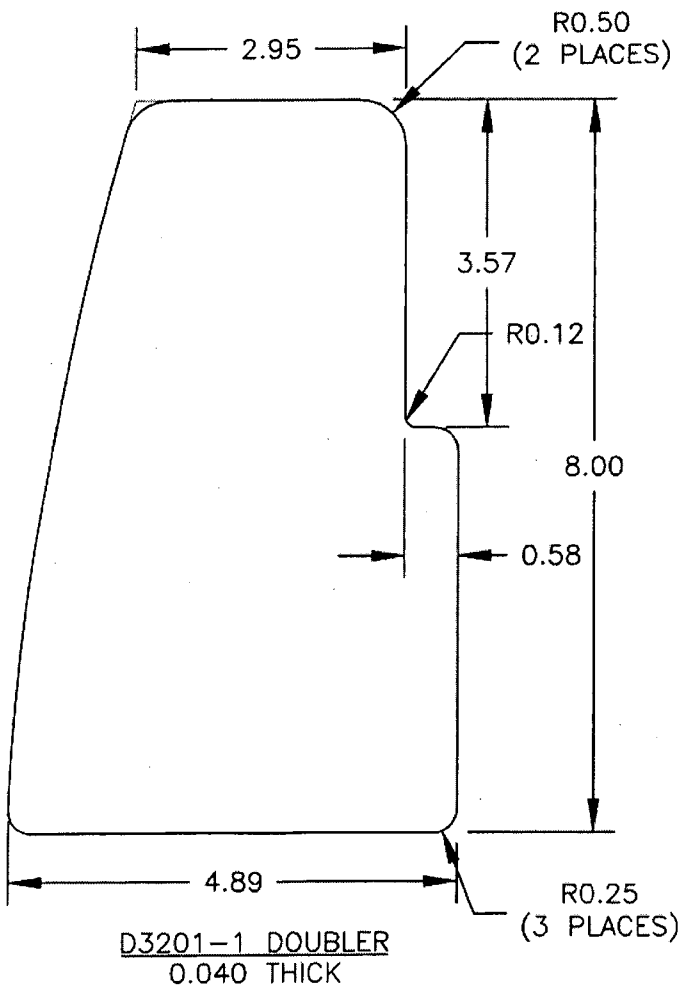
[illegible]

Measured by: <i>SAD</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>07/06/05</i>	Date: <i>07.06.05</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.28	New Issue P/O D412-698-015	KJ/RF	[Signature]

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3201	SHEET 1 OF 1
DATE		TITLE	SCALE
03.11.03		DOUBLER	1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

**RELEASED**  
03.11.14**D3201-1/-3/-4 DOUBLER**

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32474

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